

Date: Wednesday, 6/6/2007 3:04:17 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE SIDE LH (206 HI-SLOPE)
Job Number : 32819	
Estimate Number : 11000	
P.O. Number : <u>N/A</u>	Part Number : D26021
This Issue : 6/6/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2602 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 31332	Material : <u>N/A</u>
Written By : _____	Due Date : 6/30/2007 Qty: 6 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est. D 04.02.25 Reformat KJ/RF	
Note: Issue with part number D2602-2	
Est Rev:E Now On Waterjet 07-03-22 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 1.4146 sf(s)/Unit Total : 8.4874 sf(s)

2024-T3 .040 sheet

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040) Batch M103039(8)~~M100747(2)~~

SAD 07/06/15

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2602

*****Same Cutting File for -1 & -2 *****

Dwg Rev: 41Prog Rev: A1

2-Deburr if necessary

SAD 07/06/15

SAD 07/06/15

P+0

⑥

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/15

6

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 07/06/15

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2602-1 PAR #: N/A Fault Category: Prod / 488.855 ^{med & small} NCR: Yes No DQA: Yes Date: 07/08/24
 QA: N/C Closed: Yes Date: 07.08.24

NCR: <u>32819</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/15	2.0	2 Scrap wrong material B# <u>100742M60615040</u>	<u>[Signature]</u>	Scrap, destroy, replace Verify Verify the material prior to using.	SAD 07/06/15	Exp 07/06/18	<u>[Signature]</u>	Er 07/06/18

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 32819

Part Number: D26021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

SB 07/08/19 (6)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 02/08/20 (6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. J.

07/08/22

(6x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CL 07/08/22 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CS 07/08/23 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/24

Job Completion



07/08/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

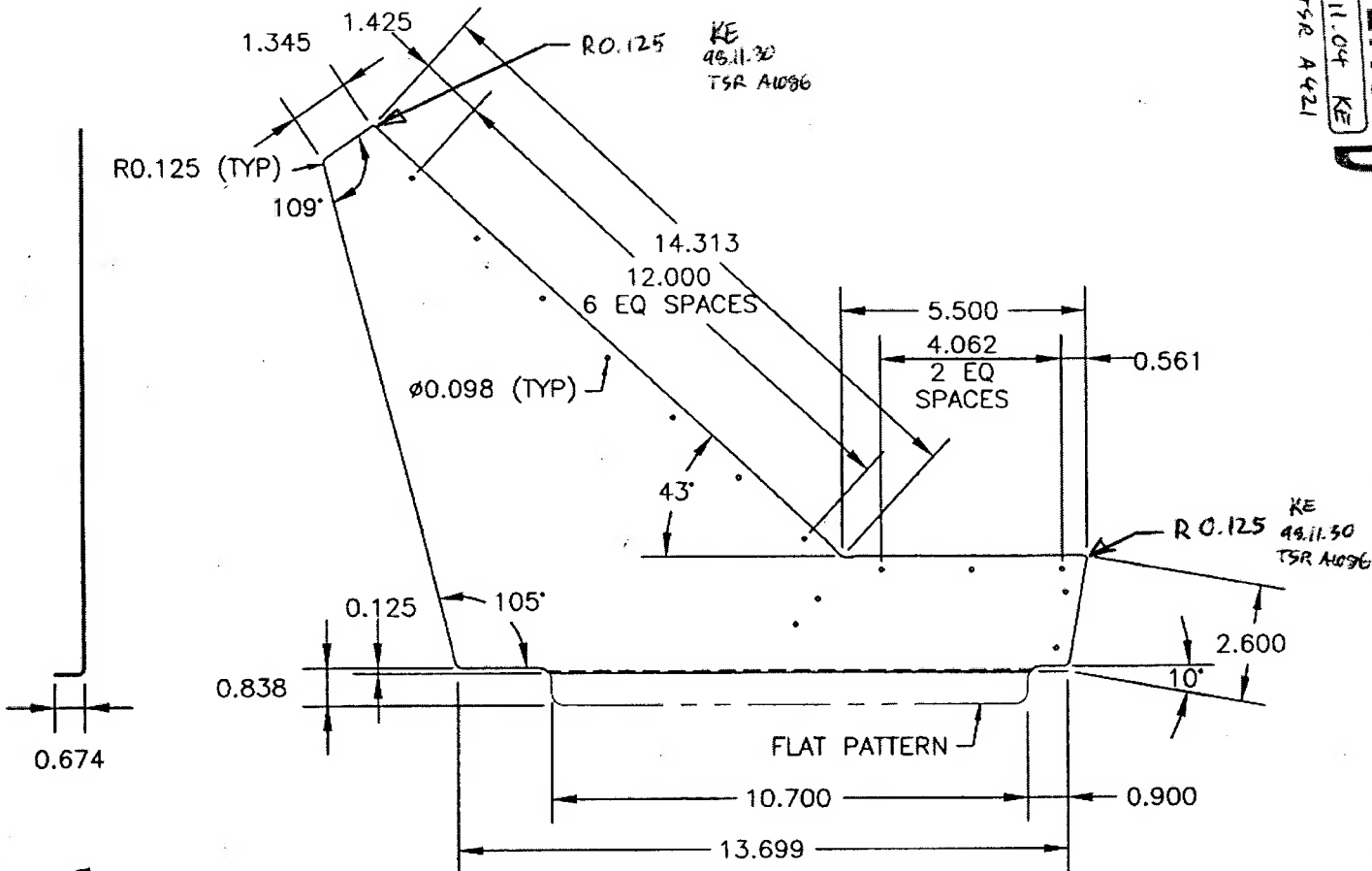
NOTE: Date & initial all entries

DART



RELEASED
97.11.04 KE
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
KE	BW	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	KE	D2602	
DATE	TITLE	SCALE	
97.10.22	CONSOLE SIDE	1:4	
A	97.10.22	D2602 WAS D206-547-21/-22	
AI	02.06.04	ADD FINISH	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2602
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 605 4.1
D2602-1 SHOWN
D2602-2 OPPOSITE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32819